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Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

Form No.

CNC/QA/FM/02

Rev. No.

01

Rev. Date

31-07-2013

Inprocess Inspection (Pellet Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14368	19/06
2	Machined By		V. T. L. H/c Shop	Drg. No. 19.02.69
3	Pallet Die No.		14937 (G-0) H/c	Rev. 203
4	Die Category	Drg. No.	M. Tumbo	
5	Out Side Diameter	Drg. No.	680.7 H/c	Step 002 692 H/c
6	Inside Diameter	Drg. No.	546.12 H/c	(Bore = 548.4 H/c)
7	Width of Pellet Die	Drg. No.	195 H/c	Step length 31 H/c
8	Grooves as per Drawing	Drg. No.	32.7 x 9.2 H/c	Under cut = 2.5 H/c
9	Fitting Sizes on CNC Plate	Drg. No.	ok	(4 x 8) H/c
10	Drilling Area Surface Smoothness		ok	Face Side Step
11	Tapping Operator		H/c Shop	2 H/c Deep Body
12	Tapping PCD		819 H/c	Side
13	Tapping Hole Diameter		M16.2 Check by H/c B.I.L	Tapping H/c
14	Tapping On Second Side	Half pitch of 1st side	ok	of holes 2
15	Tapping Hole Depth		Drill Depth 33.2 H/c	Body Side
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 20/3/25

1	As per programme no.		
2	Gun Drilling Work Completed On		
3	Hole Finish In Gun Drilling	Marked	ok
4	Defective Holes (If Any)		No

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

Counter 30°

1	Counter Sinking Depth & Finish	ok						Rev. 12
2	External Relief Dia	7.5 H/c		All Rows				
3	External Relief Depth			47 H/c				
4	Inspection Done Before Hardening By (Name)			Ravi				
5	Material Sent For Hardening By (Name)			Lark Furnace				
6	Material Sent For Hardening On Date		20	3	25			

Inspected By (Sign) & Date

Ravi 20/3/25

Reviewed by (Engineer-CNC)

Manager-QA